

Work Order ID 129577

February-17-15 9:25:29 AM

129577

Page 1

Item ID: D2844-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arms
 Start Date: 2/17/15 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 3/06/15 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2844	Rev A

100	NC BRAKE	0.00							
100									
Brake NC	Memo	0.00							
Brake NC	Form per Dwg D2844 using brake and bending Jig DT 8238-B Deburr								

10x DAS 28 9-89 ~~FEB 27 2015~~ APR 28 2015

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

(10) DAS 38 9-89 APR 30 2015

120	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
120									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:15 OVEN TEMPERATURE: 400° FINISH TIME: 9:45								

10 6 155-1 DAS 34 9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				(10)			DAS 38 9-89 MAY 01 2015
140 *140* QC Quality Control	QC6- Inspect dimensions to drawing Memo Ensure parts are still as per dwg D2844	0.00 0.00				(10)			DAS 38 9-89 MAY 01 2015
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: ⁵¹ 350 Memo	0.00 0.00				(10)			DAS 6 9-89 MAY 01 2015

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MCS MAY 04 2015

MCS MAY 04 2015

Picklist Print

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Parent Item: D2844-3

D2844-3

Parent Item Name: Arms

Start Date: 2/17/15

Required Date: 3/06/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B00.11.01Removed P/O for Powder Coat - in house processEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W.035

Purchased

No

100

f

149.8000

1.765

19

M304TR0 500W 035

304 RD Tube .500 x .035W

DAS
28
9-89

FEB 23 2015

Location

Loc Qty

Loc Code

GA002

149.8

125513

2

126922

3.5

m128084

11

m128495

61

m128833

3.8

m129188

8

m130292

60.5

~~131177~~

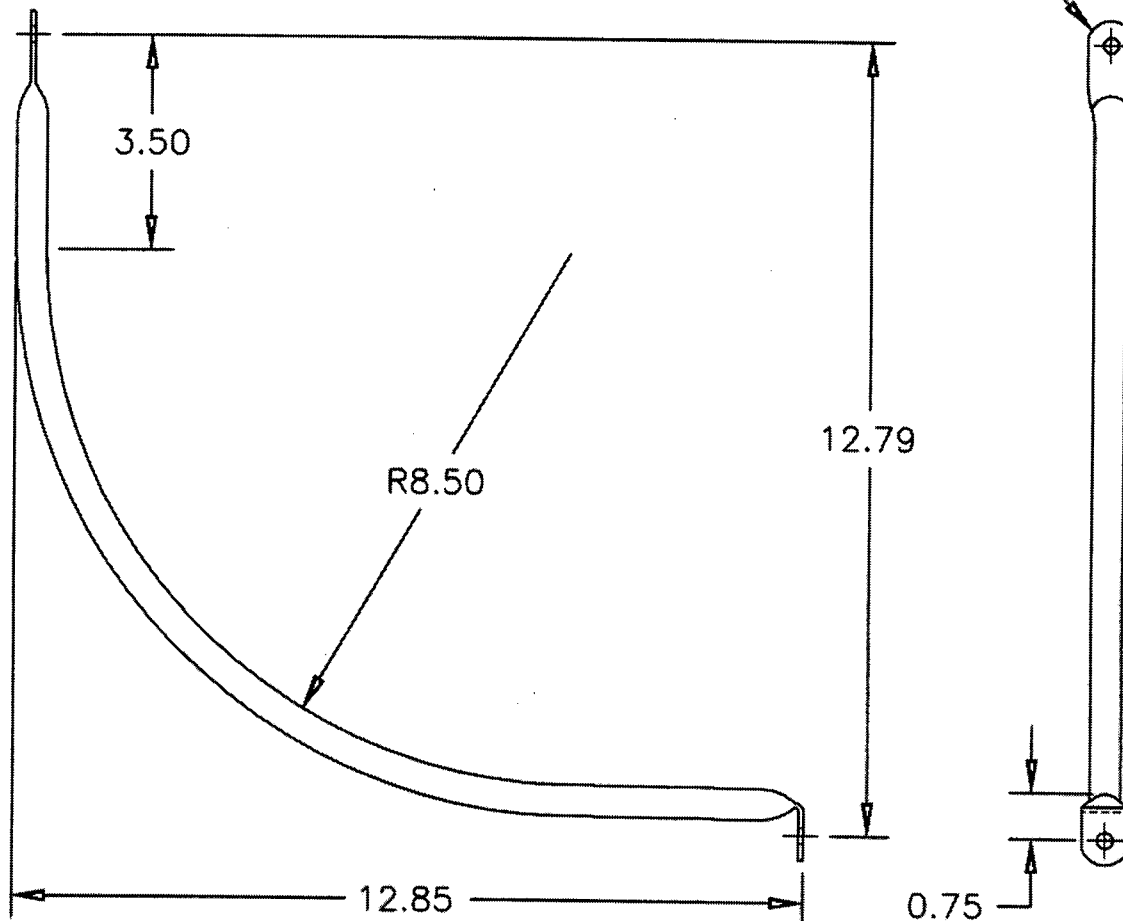
~~131717~~



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAH</i>	APPROVED <i>KE</i>	DRAWING NO. D2844	REV. A SHEET 1 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

RELEASED
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-1

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS

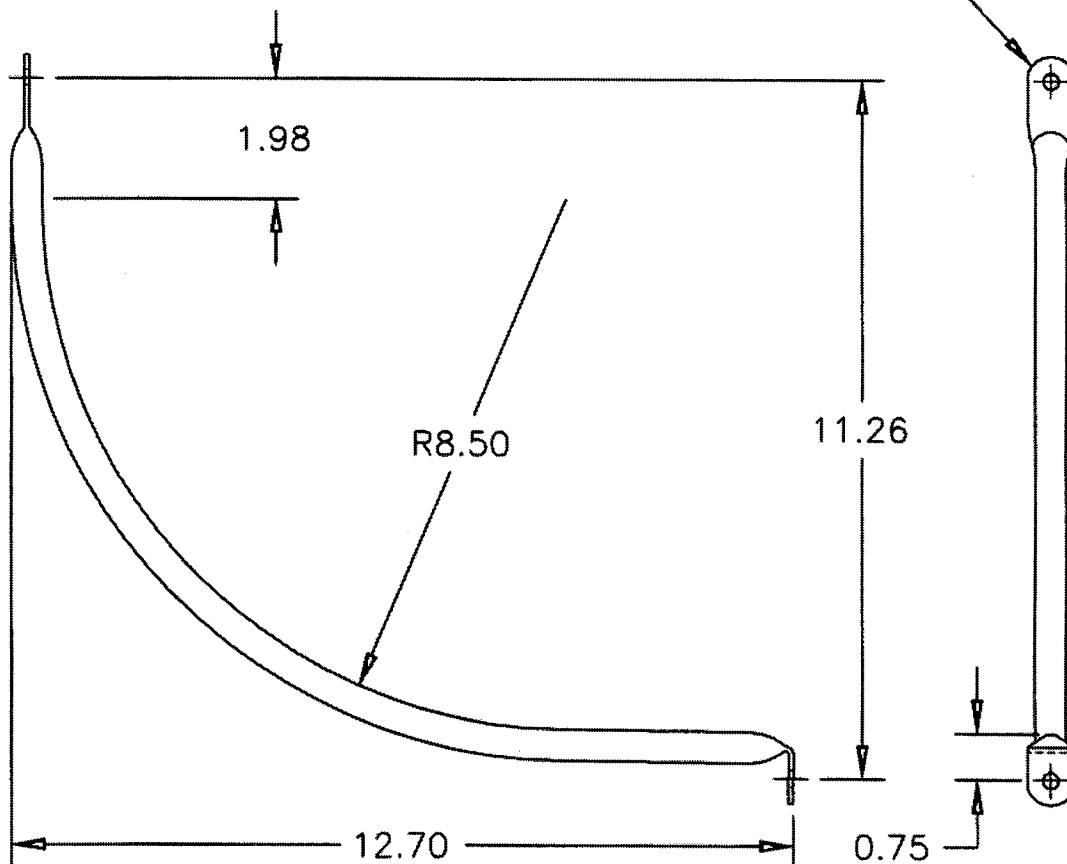
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3



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CHECKED <i>DAH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2844	REV. A SHEET 2 OF 2
DATE 98.10.14	TITLE ARM		SCALE 1:3

RELEASED
19.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-3

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL

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FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3